



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-12-3
Job Sheet 184033



Part No: C3-12-3

Job Qty: 10 ea

Part Name: Lock - C3 Hook



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-12-3 Rev. 10 IPP Rev. A 18.04.19 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-1		J.C.L.
100	Bandsaw	10 pcs	10/5/18	10/5/18	0.00	10.00	Bandsaw1		J.C.L.
120	CNC Vertical Machining	10 pcs	10/5/18	10/5/18	2.00	10.00	MORI NV5000-2		J.C.L.
130	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-5		J.C.L. 19-01-09
140	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-5		D. 19-01-10
150	Outsource	10 pcs	10/5/18	10/5/18			ATL002-VC	JAN 2 8 2019	J.C.L. 19-01-10
160	Outsource	10 pcs	10/5/18	10/5/18			GRO002-VC	10 JAN 2 8 2019	J.C.L. 19-01-10
170	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging2		DAS
180	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC6		38 DAS
190	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		21 9-88 28
200	QC21-SA	10 Ea	10/5/18	10/5/18	0.00	0.00	QC21		9-88 JAN 2 8 2019 9-89

Part Op 100 - 1- Cut 3.90" long

Descriptions: 120 - 1-Machine as per folio FC085 FOLIO REV: AA DWG REV: 10 2-Machine Engrave S/N

SEE PEC FOR PROGRAMMING NEW BATCH NUMBER EVERY TIME 3-Deburr

150 - 1--Issue P/O to Metcore ; P/O 00423241 RC 44-46 2-Bead blast 3- Certificate of Conformity is required

Material 4140 ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech or ATG***

160 - -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-

.0006 - Certificate of Conformity is required

170 - Receive

190 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.250X1.500	ALSI 4140 Steel Bar	3.2300 ft (323 ea)	90-Start up Operatic	50494.28
		OTHER END		3.916' used.

Job Allocations

Component Part	Required	Inventory	Allocated
MT-4140-B-1.250X1.500	3	5	0

Part Specifications

Specifications could not be found.



Container No: S142603



Part: C3-12-3

Job No: 184033

Serial No/Batch: S142603

Revision: 10

Inspector:

Exp Date:

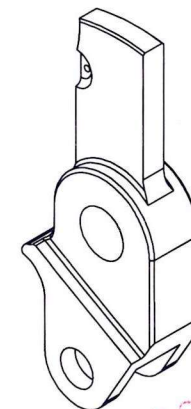
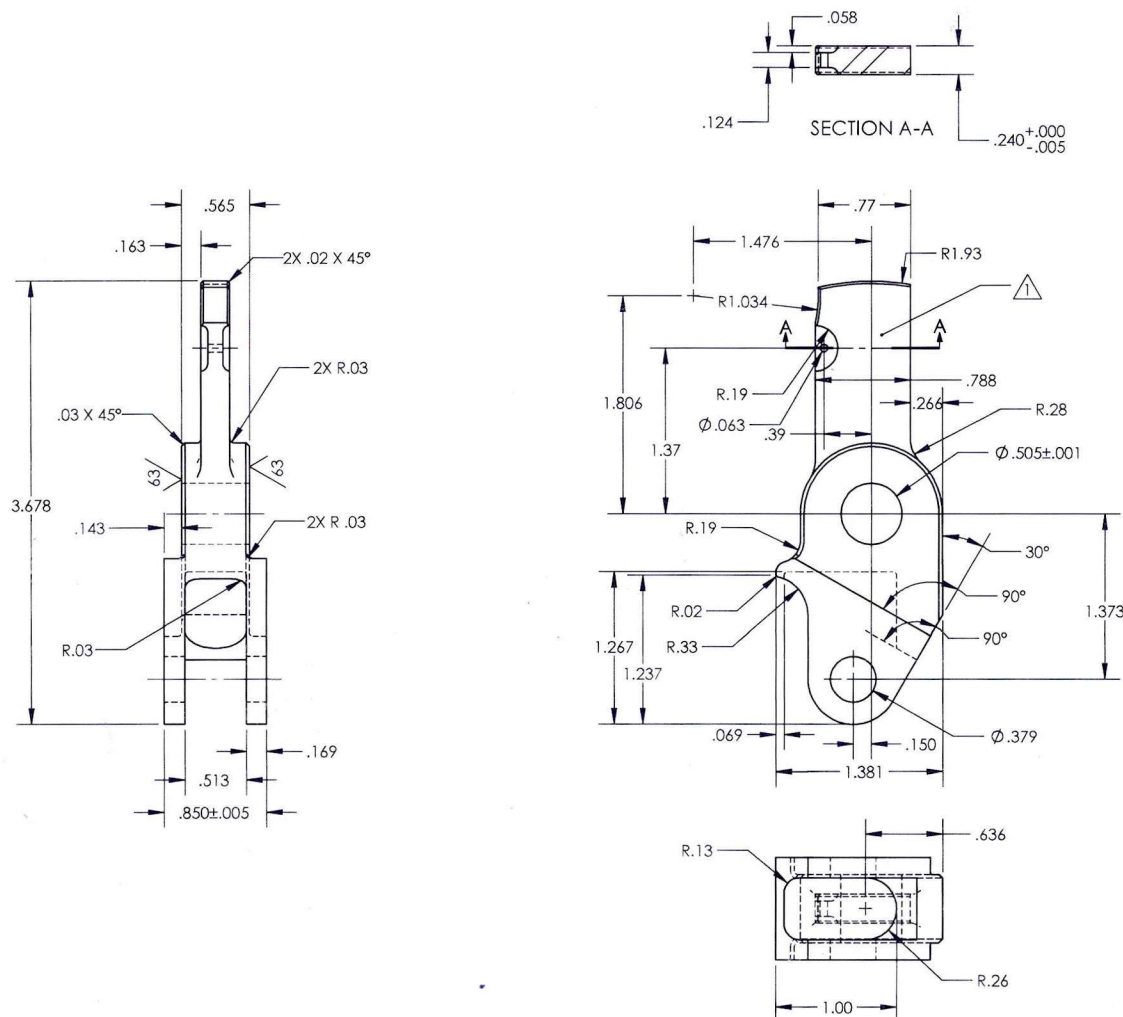
Instructions:

Date: 01/08/19

Plex 10/2/18 6:54 AM Dart.lajeunesse.marie

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
8		AS DRAWN BY CANAM	8/3/2012	RJC
9		CH'D .513 SLOT RADIUS FROM R.063 TO R.130.	10/25/2012	RJC
10	14-0109	CH'D TITLE BLOCK WAS RED BARN & DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE NON-CRITICAL DIMENSIONS, DELETED DUPLICATE DIMENSION .513.	8/7/2014	DJN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184035 MS
1870-02

NOTE:
MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK C3-HOOK	
DWG NO. C3-12-3	REV 10
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P. Reed</i>
.XXX ± .005 FRACTIONS ± 1/8	TEST RC 44-46
.XX ± .01 ANGLES ± 5°	FINISH NICKEL PLATE
1. BREAK ALL SHARP EDGES .015 X 45°	SPEC .0005 THICK
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE 10/26/2007
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-12-3	1	LOCK	4140	1 X 1-1/2 X 3-3/4	

MAT. USED

40.996
3.416

MAT. USED

40.866
4.300

3.994

4.009

4.013

4.014

3.996

3.913

4.147

3.998

3.999

4.027

~~4.000~~

2.86



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042231



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

PO No: PO042231
PO Date: 1/10/19
Due Date: 1/17/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184033	C3-12-3	Lock - C3 Hook 1--Issue P/O to Atlantic; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Atlantic to ship directly to Groupe Altech***	Firmed	-	1/17/19	10 pcs	0 pcs	10 pcs	\$17.00/pcs	\$170.00
2	187978	RBE105- 31702W23- 11	Measuring Flange Plate RH 1--Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	1 pcs	0 pcs	1 pcs	\$170.00/pcs	\$170.00
3	185001	RBE105- 31702W23- 13	Measuring Flange Plate LH 1--Issue P/O to Atlantic; P/O _____ RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	4 pcs	0 pcs	4 pcs	\$42.50/pcs	\$170.00



Dart Aerospace Ltd.
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PURCHASE ORDER PO042231



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	188092	RBE105-31702W23-13	Measuring Flange Plate LH 1-Issue P/O to Atlantic; P/O RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	4 pcs	0 pcs	4 pcs	\$42.50/pcs	\$170.00
5	185002	RBE105-31702W23-11	Measuring Flange Plate RH 1-Issue P/O to Atlantic; P/O RC 40-45 2-Bead blast ***Do not blast threads*** 3--Material type; 4140 4- Certificate of Conformity is required	Firmed	-	1/17/19	7 pcs	0 pcs	7 pcs	\$24.285714/pcs	\$170.00
Grand Total:											\$850.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Atlantic Heat Treating (2001) Ltd

Order No.: 162055

Ship Date: 1/11/2019

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7

Ship To: 159110
DART AEROSPACE LTD.
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
042231				

Quantity	Part No. / Part Name / Part Description	Pounds
	10 PCS MATERIAL 4140 ANNEAL THEN HEAT TREAT TO 44 - 46 RC C OF C , BEAD BLAST, PART # C3-12-3, JOB # 184033	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 10

Pounds Shipped: 4.00

Order No.: 162055

Shipped Complete

Quantity Shipped: 10.00

Received By:

Date:

Pounds Shipped: 4.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 01/11/2019

DAS
39
9-86

Certification

Date: 01/17/2019

Entry Date: 01/11/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: 042231

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
10	10 PCS MATERIAL 4140 ANNEAL THEN HEAT TREAT TO 44 - 46 RC C OF C, BEAD BLAST, PART # C3-12-3, JOB # 184033	4

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

Results:Harden ROCKWE 44. 46. 44. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 44 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042329



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042329
PO Date: 1/18/19
Due Date: 1/23/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184033	C3-12-3	Lock - C3 Hook -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	1/23/19	10 pcs	0 pcs	10 pcs	\$12.00/pcs	\$120.00

10x JAN 28 2019

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Certificat de Conformité / Certificate of Compliance

(016129-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016129 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
23-Jan-2019		Aman		042329					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities		À venir / Back Order	
						Qté NC/ NC Qty	Qté Scrap/		
1	C3-12-3 Rev.	C3-12-3 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK	E-NICKEL STEEL CH	10	10	0	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.